Date: Monday, 09/02/2009 4:25:55 PM
User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: FWD BLADE FOLD ASSEMBLY
Job Number	: 45643		
Estimate Number	: 13531		
P.O. Number	:	**Part Number**	: PB674300101
This Issue	: 09/02/2009 **S.O. No.** :	**Drawing Number**	: B6743001 P.1, 2
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: / / **Type** : SMALL /MED FAB	**Drawing Revision**	: B1
Previous Run	: 45642	**Material**	:
Written By	:	**Due Date**	: 15/04/2009 **Qty:** 2 **Um:** Each
Checked & Approved By	:		
Comment	: Est Rev:A 08-07-30 new issue DD verified by:ec		
	Est Rev:B 08-12-04 up date part list DD Verified by:ec		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	PB674300107	Fwd Blade Fold Assembly Weldment

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Fwd Blade Fold Assembly Weldment
batch: B45051 09-04-21

2.0	PB674300115	Fwf Adjustable Blade Support Assembly

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Fwf Adjustable Blade Support Assembly
batch: 45041 09-04-21

3.0	PB674300111	Fwf Adjustable Blade Support Assembly

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Fwf Adjustable Blade Support Assembly
batch: 45043 09-04-21

4.0	PB674300121	PB67-43001-21

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
PB67-43001-21
batch: 45038 09-04-21

5.0	PB674300123	PB67-43001-23

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
PB67-43001-23
batch: B45035 09-04-22

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

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Job Number: 45643 **Part Number:** PB674300101

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	PB674300145	Longgitudinal Support Assembly

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Longgitudinal Support Assembly
batch: 47057 → 1 45028 → 1 lpl 09-04-21

7.0	PB674300151	Long T-Handle Assembly

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Long T-Handle Assembly
batch: ~~47058~~ 45026 lpl 09-04-21

8.0	PB6743001261	Lever Arm

Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
Lever Arm
batch: 47094 lpl 09-04-21

9.0	PB6743001265	Bushing

Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)
Bushing
batch: 46932 lpl 09-04-21

10.0	PB6743001299	Bushing

Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
Bushing
batch: 43094 lpl 09-04-21

11.0	D3451041	Handle and Lock-Down Assembly

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Handle and Lock-Down Assembly
batch: 45307 lpl 09-04-21

12.0	D3451047	Handle and Lock-Down Assembly

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Handle and Lock-Down Assembly
batch: 45310 lpl 09-04-21

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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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Job Number: 45643 **Part Number:** PB674300101

Job Number:

Seq. #:	Machine Or Operation:	Description :
13.0	D34473	Square Spacer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
Square Spacer
batch: 41351 LpC 09.04.21 MF 09-04-23

14.0	D34477	Clevis

Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
Clevis
batch: 46722 LpC 09.04.21 MF 09-04-23

15.0	D34479	Swing Arm

Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
Swing Arm
batch: B41352 LpC 09.04.21 MF 09-04-23

16.0	D3445041	Belt Assembly

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Belt Assembly
batch: B46264 LpC 09.04.21 MF 09-04-23

17.0	086004	Inventory

Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
Inventory
batch: M109350 LpC 09.04.21 MF 09-04-23

18.0	MS27039104	Inventory

Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
Inventory
batch: M18431 09/04/20 (2)

19.0	MS27039123	SCREW

Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
SCREW
batch: M18057 09/04/20 (2)

Form: rprocess

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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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Job Number: 45643 **Part Number:** PB674300101

Job Number:

Seq. #:	Machine Or Operation:	Description :
20.0	MS21042L3	Nut

Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
Nut
batch: M110844 09/04/20 (x2)

21.0	MS21042L4	Nut

Comment: Qty.: 10.0000 Each(s)/Unit Total : 20.0000 Each(s)
Nut
batch: M109262 09/04/20 (x2)

22.0	MS21042L6	Nut

Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)
Nut
batch: M110002 09/04/20 (x2)

23.0	MS518596	WASHER

Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)
WASHER
batch: M108986 09/04/20 (x2)

24.0	MS518598	WASHER

Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)
WASHER
batch: M108987 → 09/04/20 (x2)
or MS51859-7 (see engineering) batch: 110193 → 8Cpl09.04.21

25.0	NAS43DD368	SPACER

Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
SPACER
batch: M110983 09/04/20 (x2)

26.0	NAS1149F0316P	WASHER

Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)
WASHER
batch: M111124 09/04/20 (x2)

Form: rprocess

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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** FWD BLADE FOLD ASSEMBLY

Job Number: 45643 **Part Number:** PB674300101

Job Number:

Seq. #:	Machine Or Operation:	Description :
27.0	NAS1149F0432P	Washer

Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)
Washer
batch: M18057 09/04/20 (X2)

28.0	NAS1149F0632P	WASHER

Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)
WASHER
batch: M18057 09/04/20 (X2)

29.0	NAS1149F0832P	WASHER

Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)
WASHER
batch: M18057 09/04/20 (X2)

30.0	AN960JD6	Washer

Comment: Qty.: 6.0000 Each(s)/Unit Total : 12.0000 Each(s)
Washer
batch: M6085 09/04/20 (X2)

31.0	AN410A	Bolt

Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
Bolt
batch: M1089986 09/04/20 (X2)

32.0	AN413A	Bolt

Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
Bolt
batch: M110731 09/04/20 (X2)

33.0	AN416A	Bolt

Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)
Bolt
batch: ~~M108471~~
or AN415A (see engineering) batch: M110359 Opl 09.04.21 ~~09/04/20~~ (X2)

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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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Job Number: 45643 **Part Number:** PB674300101

Job Number:

Seq. #:	Machine Or Operation:	Description :
34.0	AN611A	BOLT

Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
BOLT
batch: M105558 09/04/20 (x2)

35.0	AN620A	Bolt

Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
Bolt
batch: ~~M108986~~ GC
or AN6C16A (see engineering) batch: M111119 lpl 09.04.21 09/04/20 (x2)

36.0	AN813A	BOLT

Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
BOLT
batch: M110915 09/04/20 (x2)

37.0	BSP43	RIVET

Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)
RIVET
batch: M109119 09/04/20 (x2)

38.0	CR3213405	cherry rivet

Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
cherry rivet
batch: M104214 x1 M108473 x3 09/04/20 (x2)

39.0	MS17984C408	PIN, QUICK RELEASE

Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
PIN, QUICK RELEASE
batch: M108473
~~or MS17984C410~~ (see engineering) batch:
09/04/20 (x2)

39.1 grind off opposite ring flush to body. 09.03.18

Form: rprocess

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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** FWD BLADE FOLD ASSEMBLY

Job Number: 45643 **Part Number:** PB674300101

Job Number:

Seq. #:	Machine Or Operation:	Description :
40.0	MS17984C418	PIN, QUICK RELEASE

Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
PIN, QUICK RELEASE
batch: M111660 09/04/20 (x2)

41.0	30345T22	8" LANYARD

Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
8" LANYARD
batch: 108390 09/04/20 (x2)

42.0	30345T24	LANYARDS

Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
LANYARDS
batch: M111039 09/04/20 (x2)

43.0	240107	SPRING SLOTTED PIN

Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)
SPRING SLOTTED PIN
batch: M111068 09/04/20 (x2)

44.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

(x2)

Comment: SMALL & MEDIUM FAB RESOURCE 1
1- Assemble as per dwg and use 242 threadlock A/R shown on dwg PB67-43001 page 2.
242 THREADLOCK batch: M109687 CPL 09.04.22

45.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP 09/04/22 (x2)

46.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: PPP45658 9/4/23

Form: rprocess

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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Job Number: 45643 **Part Number:** PB674300101

Job Number:

Seq. #:	Machine Or Operation:	Description :
47.0	QC21	FINAL INSPECTION/W/O RELEASE

09/04/24 MF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

MF
09-04-24

Form: rprocess

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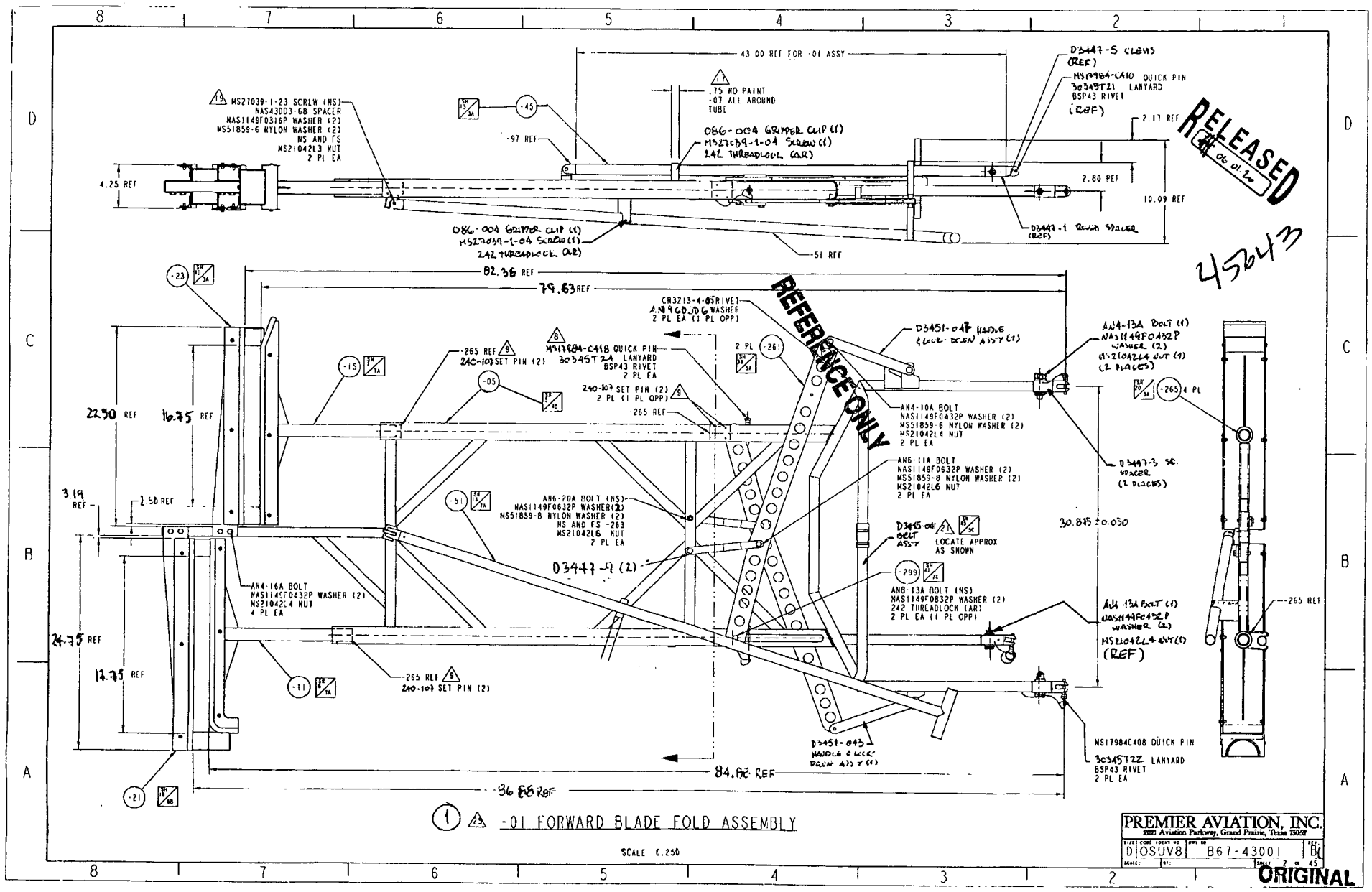
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1 ⚠2 -01 FORWARD BLADE FOLD ASSEMBLY

SCALE 0.250

PREMIER AVIATION, INC.
2021 Aviation Parkway, Grand Prairie, Texas 75052

SIZE	CODE IDENT NO	DWG NO	REV
D	0SUV8	B67-43001	B

SCALE: WT: SHEET 2 OF 45

ORIGINAL